

Work Order ID 67252/

Monday, March 14, 2011 10:43:53 AM

BLUE



Page 1

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 3/14/2011 Start Qty: 1.00

Required Date: 3/25/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

CL

Date:

4/6/3/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

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Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

**Memo**

0.00

1-Debur Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod ☐

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 &amp; DT8169 (A,B,C,D). Open to Ø0.312".

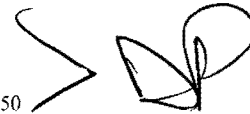
7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650

11-Debur and Blow out all chips from inside the tube



11-3-16

BE 11-3-23

BE 11-3/23

BE 11/03/23

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00



8 u103/05

QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00



8 u103/05

QC

Memo

0.00

Quality Control



120

Chemical Conversion Coat per QSI005 4.1

0.00



0.00

HandFinish

Memo

0.00

Hand Finishing

B 11/05/28

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Item Name: Replacement Skidtube

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11-3-29

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Item ID: D206-642-441

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Setup Start



Revision ID:

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Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

0.00

Skidtubes

Memo

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail  
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.  
cure time before cutting☐

Start Date: 11/03/31

Time: ☐ 11:00☐

Finish Date: 11/03/31

Time: ☐ 11:30A/R ☐ Sikaflex-291 ☐ 116090 ☐Sikaflex expiry date: ☐ 11/09/30

3 BE 11/03/29

BB

11/03/31

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*See notes*

Memo

0.00

160



Skidtubes

Skidtubes

Skidtubes

Memo

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod *min 385*

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr

0.00

0.00

*1 2 BE 11/6/06**> [Signature] 11-4-7*

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Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Skidtubes Skidtubes	HandFinishing  Memo Install D2680-041 Nut Plate as per Dwg D2650	0.00 0.00							
			DP	11-4-7					
180  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00							
			Swaylos						
190  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
			Swaylos			@			

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Revision ID:

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

1 0 4 11

205

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

Spray Painting

Spray Painting:  
prime grey B: 117319  
spray paint delfleet blue B: 115985  
clear delfleet B: 117113

11 04 26 1

220

QC 14 Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11 04 27 1

225

QC 14 Inspect Paint

11 04 27 1

Permanent Change



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Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

0.00



HandFinishing

0.00

HandFinish

Memo

Hand Finishing

1-Install inserts &amp; wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☐ M116040Sikaflex expiry date: ☐ 11/08

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☐ M116040Sikaflex expiry date: ☐ 11/08

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: 1117375

1 0 30 4/10/11

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 04 28 17

250

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-441

Location:

PPP Rev:

PAP 67248

11/07/31

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/94

ME 11-05-03

# Picklist Print

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Page 1

Work Order ID: 67252

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube


Start Date: 3/14/2011

Required Date: 3/25/2011


Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM  
 IPP Rev:I 08-05-01 add QC3 DD verified by:EC  
 IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K  
 10.09.27 SS washers for wearplates EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620  Skidtube, 206 Skidtube		Manufactured	No			110	Each	15.0000	1	1			


Location	Loc Qty	Loc Code
LG	15	
62684	6	
64784	9	

D2646  Aft Cap	Manufactured	No			110	Each	71.0000	1	1				
---	--------------	----	--	--	-----	------	---------	---	---	--	--	--	--

Location	Loc Qty	Loc Code
FP-4	1	
57332	1	
FP6	16	
52663	3	
62678	12	
63633	1	
Return 2010	54	
62678	54	

D2647  Cap	Manufactured	No			140	Each	51.0000	1	1				
---	--------------	----	--	--	-----	------	---------	---	---	--	--	--	--

Location	Loc Qty	Loc Code
LG002	51	
55352	51	

  
 11-3-10  
 ul 04/27

367263

X1

BE 11/03/23



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Work Order ID: 67252



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-7 Manufactured No

160 Each

4.0000

1

1



Web

67601



1

11/03/31

Location

Loc Qty

Loc Code

LG

4

67016

4

CCR264SS3-3

Purchased No

170 Each

332.0000

2

2



Cherry Rivet



Location

Loc Qty

Loc Code

ST311

332

112314

4

113539

44

113973

88

117086

196

2 11-4-7

D2649

Manufactured No

170 Each

120.0000

23

23



Cross Bolt Spacer



BE 11/07/06

Location

Loc Qty

Loc Code

LG001

120

58545

2

60652

4

61496

2

62889

11

63359

3

65317

98

23

D2680-041

Manufactured No

170 Each

14.0000

1

1



Nut Plate



Location

Loc Qty

Loc Code

ST020

14

55366

14

1 11-4-7

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Shop Packet Print

# Picklist Print

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Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

230

Each

626.0000

60

60



Handwritten: 31 11/04/27

Insert

Location

Loc Qty

Loc Code

PKG11

491

M1173D1

Handwritten: x60

114723

42

116864

449

ST281

135

110511

10

114654

39

115911

86

AN960JD10L

NAS1149D0332L

Purchased

No

230

Each

4.0000

2

2



M117291



Handwritten: (x2) 31 11/04/27

Washer

Location

Loc Qty

Loc Code

ST335

4

11912

4

AN960JD416

NAS1149D0463J

Purchased

No

230

Each

30.0000

1

1



Handwritten: 31 11/04/27

Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

M116805

Handwritten: x1

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Shop Packet Print

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Work Order ID: 67252



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

230

Each

1,837.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

MEZZ

1837

110139

2

110153

35

111359

5

112314

2

114436

448

114450

31

114859

1314

D2651-1

Manufactured

No

230

Each

571.0000

22

22



Plug

Location

Loc Qty

Loc Code

FP

189

51530

152

62638

37

fpa

382

53349

205

57869

117

66445

60

D2651-3

Manufactured

No

230

Each

404.0000

22

22



O-Ring

Location

Loc Qty

Loc Code

FP

404

46114

12

61962

392

② 11-4-7

1367263

x22

1104/22

x22

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Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-15	Manufactured	No	230	Each	22.0000	1	1
							<u>22 11/04/27</u>
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP18	22	
63569	3	
<u>66238</u>	6	<u>x2</u>
66558	13	

D3535-23	Manufactured	No	230	Each	18.0000	1	1
							<u>18 11/04/27</u>
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP021	18	
63571	4	
<u>66236</u>	13	<u>x1</u>

D3535-37	Manufactured	No	230	Each	7.0000	1	1
							<u>7 11/04/27</u>
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	7	
56101	1	
<u>62716</u>	6	<u>x1</u>

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Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011


Required Date: 3/25/2011

Start Qty: 1.00


Required Qty: 1.00

D3536-15      Manufactured      No      230      Each      36.0000      1      1  
      yl      11/04/27  
 Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	1	
56055	1	
FP011	34	
<u>63568</u>	8	
66559	26	X1
FP11	1	
59238	1	

D3536-23      Manufactured      No      230      Each      36.0000      1      1  
      yl      11/04/27  
 Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	10	
<u>66240</u>	10	X1
FP011	26	
63570	1	
66560	25	

D3536-37      Manufactured      No      230      Each      24.0000      1      1  
      yl      11/04/27  
 Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	24	X1
<u>63237</u>	12	
66823	12	



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Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No

230 Each

28.0000

6

6



Wearpad



HL 11/04/27

Location

Loc Qty

Loc Code

FP017

28

366935

x6

37749

5

65057

23

D3537-3 Manufactured No

230 Each

20.0000

1

1



Wearpad



HL 11/04/27

Location

Loc Qty

Loc Code

FP17

20

65929

20

x1

MS27039-1-08 Purchased No

230 Each

1,059.000

2

2



Screw



HL 11/04/27

Location

Loc Qty

Loc Code

ST291

1059

110835

319

115108

740

x2

MS27039-4-06 Purchased No

230 Each

91.0000

1

1



Screw



HL 11/04/27

Location

Loc Qty

Loc Code

ST292

91

109061

4

115460

87

x1

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Work Order ID: 67252

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-08

Purchased

No

230

Each

959.0000

60

60



92 11/04/27

SCREW

Location

Loc Qty

Loc Code

FP

63

115336

63

ST293

896

115589

347

116022

148

116373

400

19185

1

X60

NAS1149C0332R

Purchased

No

230

Each

1,958.000

60

60



92 11/04/27

Washer

Location

Loc Qty

Loc Code

ST297

1958

115000

125

115698

35

116025

28

116304

1770

1117291

X60

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

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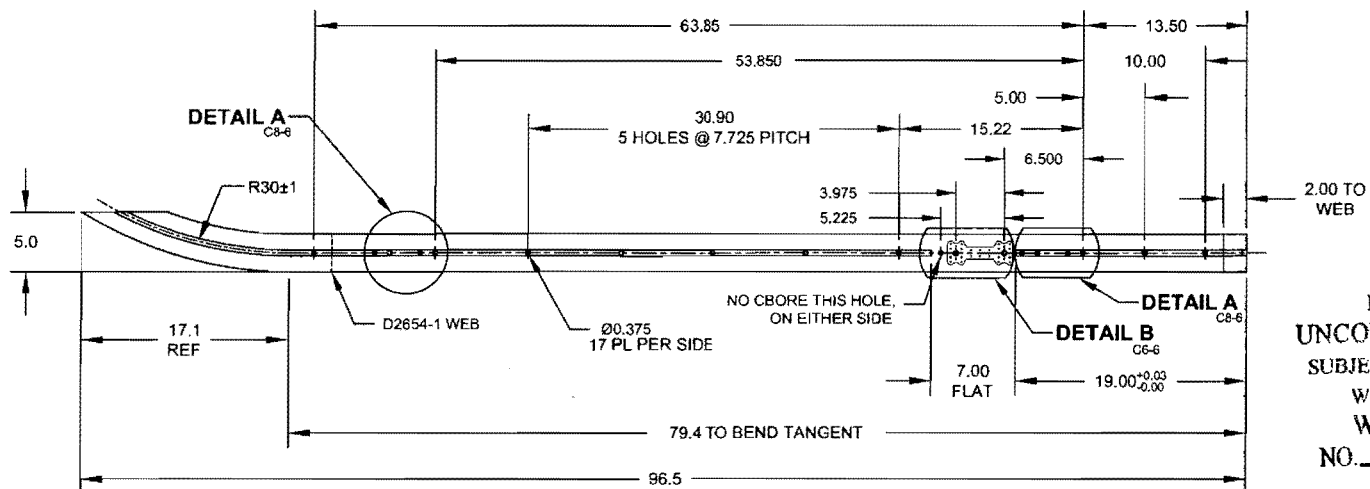
02/11/03/14

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**NOTES:**

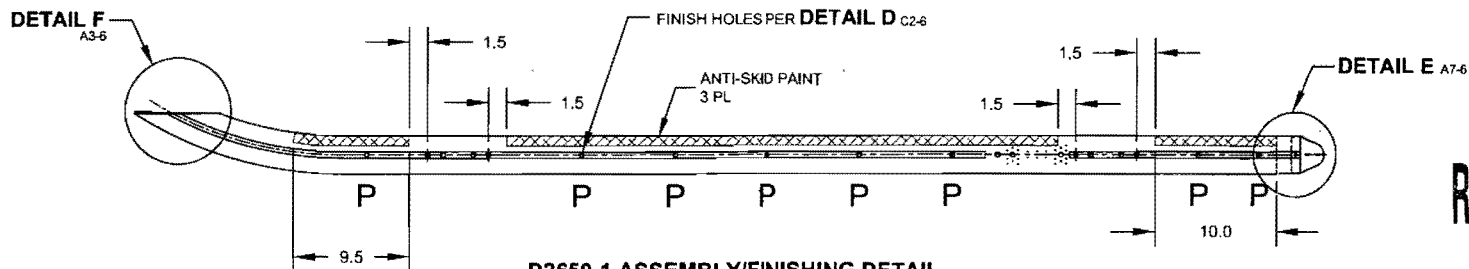
- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	08.03.30
D	REDRAW: INCCRP, DEC9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
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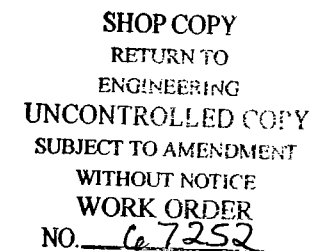
**D2650-1 BENDING/DRILLING DETAIL**







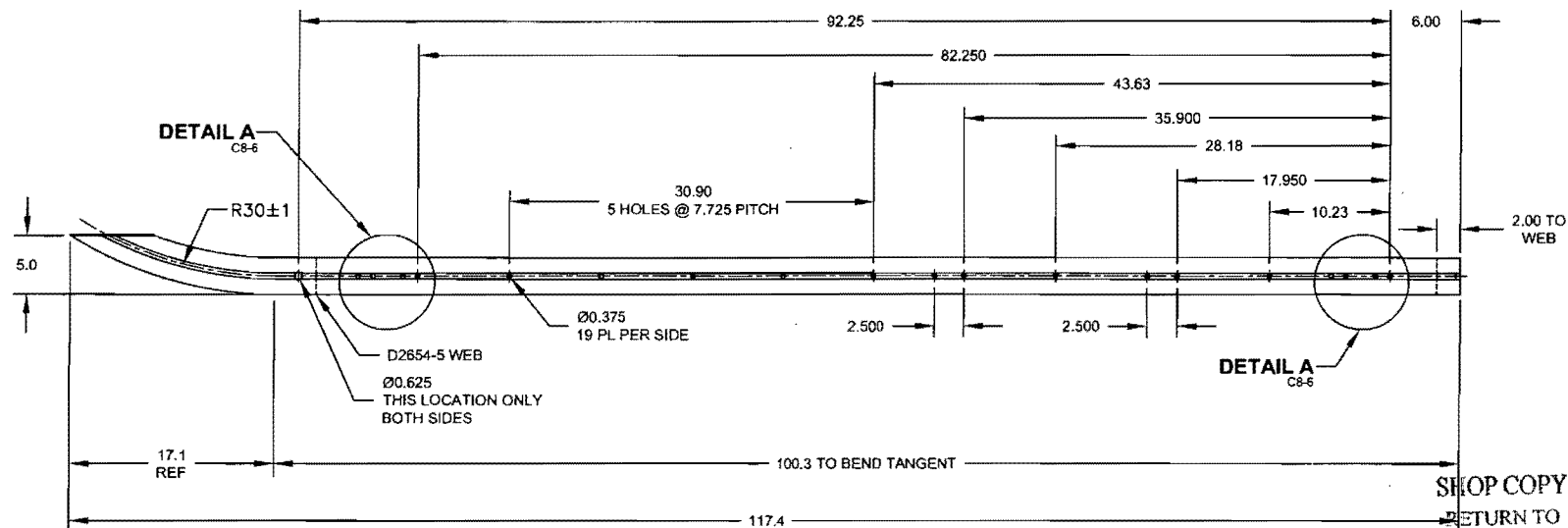
**D2650-1 ASSEMBLY/FINISHING DETAIL**

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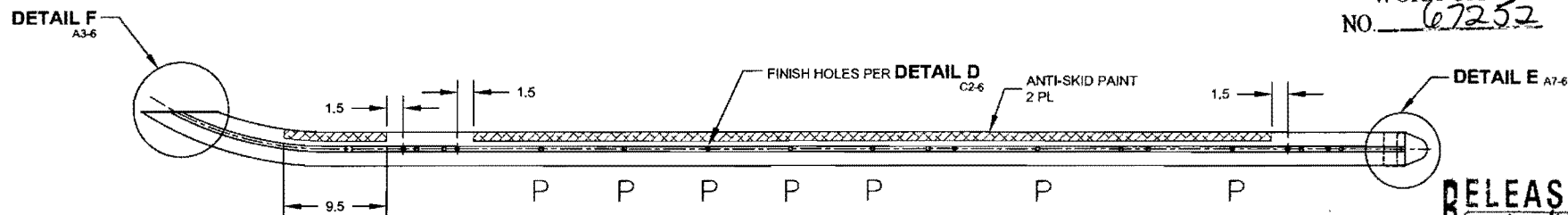


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8

7

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2

1

D

C

B

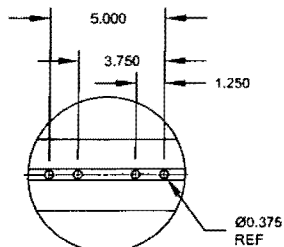
A

D

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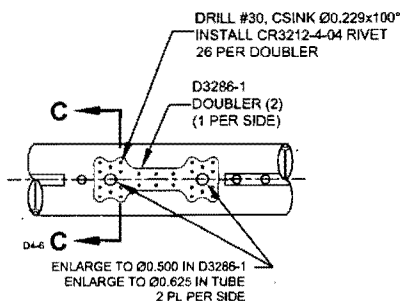
B

A



**DETAIL A**  
SCALE 2X

C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5

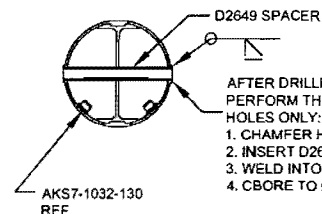
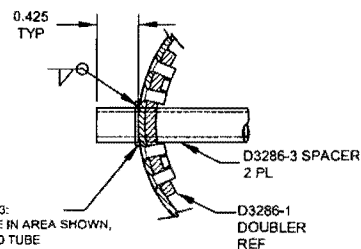


**DETAIL B**  
SCALE 2X

C3-2  
C3-3

- TO INSTALL D3286-1A3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE.

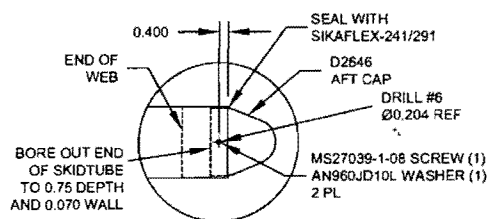
**SECTION C-C**  
SCALE NONE



**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X

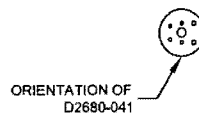
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B4-5

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**DETAIL E**  
SCALE 2X

B2-2  
B2-3  
B1-4  
B1-5



**DETAIL F**  
SCALE NONE



B6-2  
B6-3  
B6-4  
B6-5

**DETAIL F NOTES:**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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NO. 246

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 66462  
Part number: D206-642-441  
Description: 206 skirt tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Lums Date of Test Coupon 11-03-09  
Welder Barclay Elliott Date of Test Coupon 11-03-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld